

# Work Order ID 80913

**\*80913\***

Page 1

March-05-12 10:45:44 AM

Item ID: 41232-200-001-001 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Actuator LH Ass'y  
 Start Date: 05/03/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 19/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/05 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
41232-200-001	Rev IR

100 0.00  
**\*100\*** Small Fab  
 Small Fab Memo 0.00  
 Small Fab 1- Assemble as per Dwg 41232-200-001 2-Torque as per Dwg 41232-200-001

FF 12-06-04

110 0.00  
**\*110\*** QC5- Inspect part completeness to step on W/O  
 QC Memo 0.00  
 Quality Control

12-06-04

120 0.00  
**\*120\*** Identify as per dwg & Stock Locations ST  
 Packaging Memo 0.00  
 Packaging

12-6-5

PPPS0908

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80913****\*80913\***

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March-05-12 10:45:44 AM

Item ID: 41232-200-001-001

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Step Actuator LH Ass'y

Stop

**\*NS2\***

Start Date: 05/03/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 19/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/6/5  
MF  
12-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 80913

\*80913\*

Parent Item: 41232-200-001-001

\*41232-200-001-001\*

Parent Item Name: Step Actuator LH Ass'y

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-02-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
41232-200-002-001		Manufactured	No			100	Each	0.0000	1	1			
*41232-200-002-001*					809114				**	1		FF 12-06-04	
tube													
41232-200-002-003		Manufactured	No			100	Each	8.0000	1	1			
*41232-200-002-003*									**			FF 12-06-04	
latch													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST364	8							
					43304	8				1			
41232-200-002-005		Manufactured	No			100	Each	16.0000	1	1			
*41232-200-002-005*									**			FF 12-06-04	
pivot arm													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST364	16							
					43305	8				1			
					44347	8							
41232-200-005-003		Manufactured	No			100	Each	11.0000	2	2			
*41232-200-005-003*									**			FF 12-06-04	
Spacer (Step Actuator)													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					st364	1							
					30501	1							
					61028	10				2			
41232-200-008-001		Purchased	No			100	Each	0.0000	1	1			
*41232-200-008-001*									**	1		FF 12-06-04	
Decal					B 80915								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 80913

\*80913\*

Parent Item: 41232-200-001-001

\*41232-200-001-001\*

Parent Item Name: Step Actuator LH Ass'y

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN315-4R Purchased No

100 Each 34.0000 1 1

\*AN315-4R\*

Nut

\*\*

FF 12-06-04

Location

Loc Qty

Loc Code

ST344

34

17566

34

AN3-22A Purchased No

100 Each 30.0000 1 1

\*AN3-22A\*

Bolt

\*\*

FF 12-06-04

Location

Loc Qty

Loc Code

ST352

30

110998

20

111072

10

AN842-4D Purchased No

100 Each 2.0000 1 1

\*AN842-4D\*

Elbow

\*\*

FF 12-06-04

Location

Loc Qty

Loc Code

ST328

2

115299

2

AN960JD10 NAS1149D0363J Purchased No

100 Each 0.0000 2 2

\*AN960JD10\*

Washer

\*\*

2

FF 12-06-04

AN960JD416 NAS1149D0463J Purchased No

100 Each 22.0000 2 2

\*AN960JD416\*

Washer

\*\*

FF 12-06-04

Location

Loc Qty

Loc Code

ST351

22

121912

22

116289

2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: 41232-200-001-001

\*41232-200-001-001\*

Parent Item Name: Step Actuator LH Ass'y

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3975-041 Manufactured No

100 Each 6.0000 1 1

\*D3975-041\*

Gas Cylinder Assembly, LH

\*\*

FF 12-06-04

## Location

## Loc Qty

## Loc Code

ST079

6

60409

2

61798

4

MS16996-23

Purchased No

100 Each 399.0000 1 1

\*MS16996-23\*

cap screw

\*\*

FF 12-06-04

## Location

## Loc Qty

## Loc Code

ST333

399

112492

399

MS20822-4

Purchased No

100 Each 1.0000 1 1

\*MS20822-4\*

elbow

\*\*

FF 12-06-04

## Location

## Loc Qty

## Loc Code

ST299

1

110363

1

MS21042L3

Purchased No

100 Each 3,742.000 1 1

\*MS21042L3\*

Nut

\*\*

FF 12-06-04

## Location

## Loc Qty

## Loc Code

ST300

3742

117441

16

117885

32

118451

5

118927

3

119017

3489

119075

197

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: 41232-200-001-001

\*41232-200-001-001\*

Parent Item Name: Step Actuator LH Ass'y

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 1.00

Required Qty: 1.00

S-1455

Purchased

No

100

Each

65.0000

1

1

**\*S-1455\***

spring-step actuator (replaces 71459)

\*\*

FF 12-06-04

Location

Loc Qty

Loc Code

ST396

65

110154

37

111342

28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

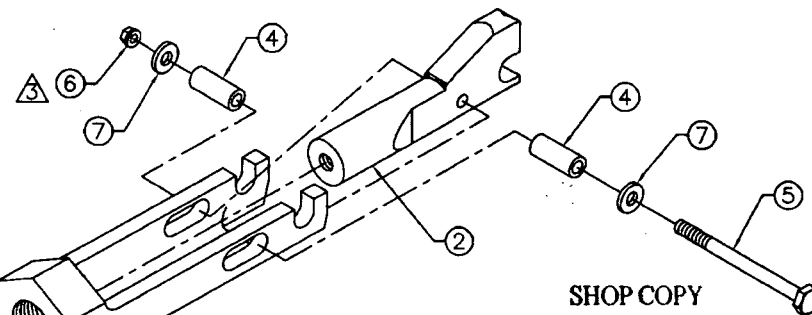
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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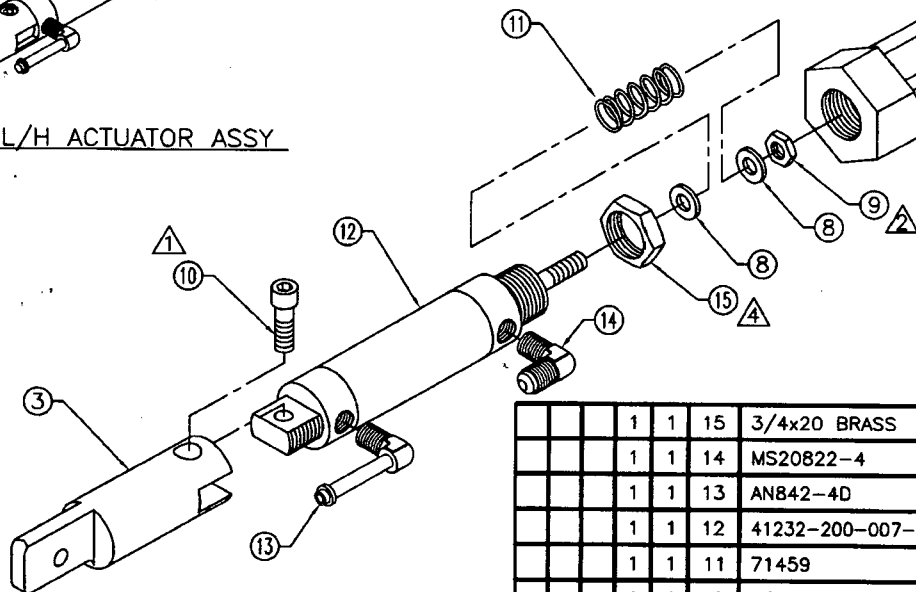
**NOTE:** Date & initial all entries

-001 L/H ACTUATOR ASSY

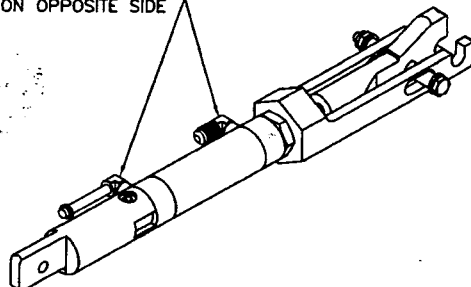


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER





NO. 80913 ALJ  
12/03/05



INSTALL ITEM #12  
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY

-  TORQUE 80-100 IN.-LB.  
 TORQUE 20-25 IN.-LB.  
 TORQUE 50-75 IN.-LB.  
 TORQUE 50-75 IN.-LB.

NOTES:

			1	1	15	3/4x20 BRASS	CYLINDER NUT						
			1	1	14	MS20822-4	ELBOW						
			1	1	13	AN842-4D	ELBOW						
			1	1	12	41232-200-007-001	CYLINDER						
			1	1	11	71459	SPRING						
			1	1	10	MS16996-23	CAP SCREW						
			1	1	9	AN315-4R	NUT						
			2	2	8	AN960JD416	WASHER						
			2	2	7	AN960JD10	WASHER						
			1	1	6	MS21042-L3	NUT						
			1	1	5	AN3-22A	BOLT						
			2	2	4	41232-200-005-003	SPACER						
			1	1	3	41232-200-002-005	PIVOT ARM						
			1	1	2	41232-200-002-003	LATCH						
			1	1	1	41232-200-002-001	TUBE						
						-002	R/H ACTUATOR ASSY						
						-001	L/H ACTUATOR ASSY						
			-002	-001	END NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE		
NO. REQ'D PER ASSY													
LIST OF MATERIAL													
UNLESS OTHERWISE SPECIFIED X±.1 XOL±.03 XOO±.010 ANGLES ±.1/2°													
DRAFTSMAN D. NELSON 5/20/02													
CHECK D. MURPHY 5/20/02													
STRESS													
PROL													
ENGR.													
HEAT TREAT													
FINISH													
TITLE STEP ACTUATOR ASSY													
DWG. SIZE C													
SCALE NONE													
DWG. NO. 41232-200-001													
REV. IR													
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-002 -001 1 41232-000-001													
NEXT ASSEMBLY													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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